

Date: Thursday, 3/8/2007 3:41:03 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	CUFF	
Job Number	31150				
Estimate Number	12774				
P.O. Number	<u>N/A</u>		Part Number	D36061	
This Issue	3/8/2007	S.O. No. <u><i>N/A</i></u>	Drawing Number	D3606	
Prsh Rev.	NC		Project Number	N/A	
First Issue	<u><i>N/A</i></u>	Type MACHINED PARTS	Drawing Revision	UNDER REVIEW	
Previous Run	31024		Material	<u><i>N/A</i></u>	
Written By			Due Date	3/30/2007	Qty: 6 Um: Each
Checked & Approved By	<u><i>07.03.08</i></u>				
Comment	est rev A new issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6R3500 <i>07.03.16</i>	Inventory
Comment: Qty.: 0.5250 f(s)/Unit Total : 3.1500 f(s) 7075-T6 6061-T6 round bar 3.500" dia. batch: <u>1326548</u> section of D6009-12A x-Lube extrusion.		
2.0	MORI SEIKI 	MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI CNC LATHE LARGE		
1-Turn as per folio FA & DWG D3606, FOLIO REV: <u><i>N/A</i></u> DWG REV: <u><i>A</i></u>		
2-Deburr as required		
3.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8 	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.03.16	1	USE 7075-T6 ROUND BAR PER DWG				UP 07.03.16 per QS1042	/
							07.03.21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 31150

Part Number: D36061

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



70703-21 (6)



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pack/03/01 (6)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

707103 123

Job Completion



707103 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

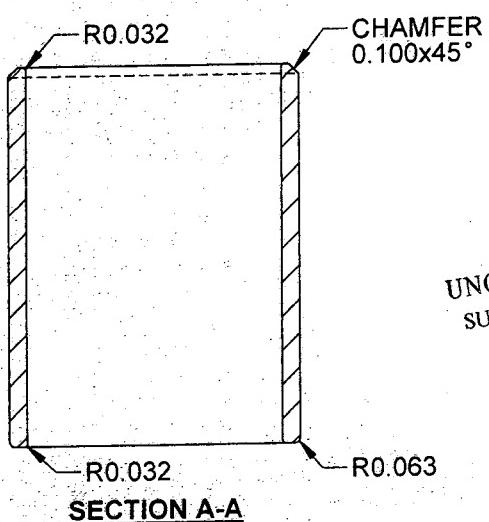
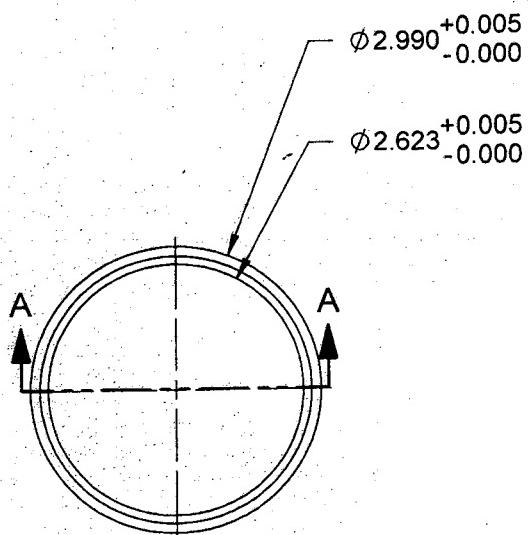
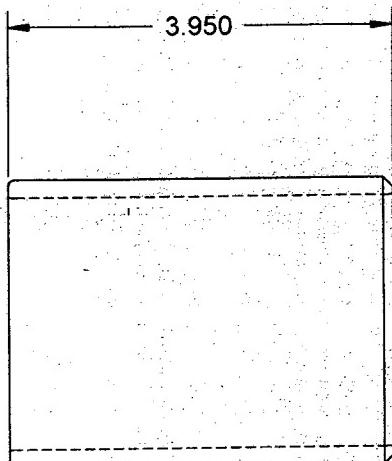
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	07.03.01	TITLE	SHEET 1 OF 1
		D3606	SCALE 1:2
A	07.03.01	NEW ISSUE	

PRELIMINARY ISSUE
P.07.03.01



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3150

D3606-1 CUFE

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DART AEROSPACE LTD

Work Order: 31150

Description: CUFF

Part Number: D3606

Inspection Dwg: D3606 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.950	+ .010 -.000	3.948	✓			
B Ø 2.990	+ .005 -.000	2.993	✓			
C Ø 2.623	+ .005 -.000	2.625	✓			
D .100 X 45°	+ .010 -.000	.102	✓			
E Ø 2.062	+ .010 -.000	2.062	✓			
F Ø 2.032	+ .010 -.000	2.032	✓			
G						
H						
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J						
K						
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R						
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T						
U						
V						
W						
X						
Y						

Measured by:	RG
Date:	07.03.16

Audited by:	Er
Date:	07/03/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
1		New Issue	KJ/RF	